

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020251**Date Inspected:** 02-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yu Dong Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH (NWIT # 06828)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK7ASD1-001-005, 006, 018, 021
 BK4ASD1-025-005, 006, 018, 021
 BK4ASD1-026-005, 006, 018, 021
 BK4ASD1-027-005, 006, 018, 021
 BK4ASD1-028-005, 006, 018, 021
 BK4ASD1-029-005, 006, 018, 021
 BK4ASD1-030-005, 006, 018, 021
 BK4ASD1-031-005, 006, 018, 021
 BK4ASD1-032-005, 006, 018, 021
 BK4ASD1-033-005, 006, 018, 021

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BAY 11, OBG BIKE PATH (NWIT # 06830)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A1-023-009 (GREEN TAG NO. 14335)

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11

BIKE PATH BK005A-003

During random in process inspection this QA inspector observed that ABF NDT personnel performing Magnetic Particle Testing (MT) on the weld joints of stringer plate for above mentioned bike path. The members are identified as OBG components.

BIKE PATH (HSR-9503)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joints of deck plate to stringer plate of bike path. The QC monitoring HSR is identified Mr. Shao Hai Lang. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A-020

OBG BIKE PATH BK005B-002

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up of the stringer plate to deck plate of above mentioned bike path. The welder is identified as 057331. ZPMC QC is identified as Mr. Zhao Mao Mao. The welding variables recorded by QC appeared to comply with WPS-B-P 2112. The members are identified as OBG components.

EAST TOWER LIFT 5, GRILLAGE PLATE REPAIR ON SKIN A EXTERIOR

SMAW welding of weld joint 002A/B(Repair) located on ESD1-TL5-2B/F (T-WR3691).

Welder is identified as 041271. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-385-SMAW-3G(3F)-REPAIR.

SMAW welding of weld joint 008A/B(Repair) located on ESD1-TL5-2B/F (T-WR3692).

Welder is identified as 046769. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-385-SMAW-3G(3F)-REPAIR.

BAY 10

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OBG BIKE PATH

FCAW welding of weld joint 059 & 060 located on BK004A8-028.

Welder is identified as 053116. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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